



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-636-012
Job Sheet 196267



Part No: D350-636-012

Job Qty: 1 pcs

Part Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Due Date: 7/19/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D2750-042 REV.H IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM IPP REV:S 18.11.12 AS PER DWG REV.H DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/19/19		0.00	4.36	Skidtubes - 1		TF BE
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	7/19/19		0.00	0.00	QC 10 - 10		DAS 43 9-89
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	7/19/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		

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				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
140 Handfinish - 1-1 Chemical-B4B	1 pcs	7/19/19	0.00 0.91	Handfinish - 1 - 1 - B4B	JUL 19 2019 9:09 101 19-7-27
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	7/19/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	DB
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	

Job BOM

011901

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	110-Skiddtubes - 1	194944
D2744	Cap	1 pcs (1 ea)	110-Skiddtubes - 1	5192776
D2739	350 I-Beam	1 pcs (1 ea)	160-Skiddtubes - 2 - B4B	5193743
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skiddtubes - 2 - B4B	5182366
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skiddtubes - 2 - B4B	5186278
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skiddtubes - 2 - B4B	5188671
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5192155
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	5703283
AN3C8A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167183
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5160263
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5192376
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5206358
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5185281
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184402
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5205437
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	5264500
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5201871
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5208541
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5202005
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	51421407
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5192757
NAS1149C0332R	Washer	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5193137
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5046013-7
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5214921
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5057658
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5170225
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5201910
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184409
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5197663
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5199486
D3532-1	Spacer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5163195
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167203
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718

012026

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skiddtubes - 1	D2600-3-BENT-RH	1	5	0
	D2744	1	0	0
160-Skiddtubes - 2 - B4B	D2739	1	17	0
	D2743	8	167	0
	D3490-1	4	202	0
	D3490-3	4	94	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	38	949	0
	AN3C5A	34	1,084	0
	AN3C6A	4	205	0
	AN6C44A	4	166	0
	AN8C35A	1	35	0
	D2745	8	168	0
	D3488-4	1	19	0
	D3492-1	8	143	0
	D3492-3	8	99	0
	D3537-1	3	56	0
	D3631-1	8	492	0
	D3791-1	1	2	0
	D3793-1	1	17	0
	D3793-3	1	13	0
	D3793-5	1	0	0
	MS21043-6	4	159	0
	MS21083C8	1	110	0
	NAS1149C0332R	38	2,780	0
	NAS1149C0832R	1	313	0
	NAS1515H3L	4	234	0
	NAS1611-010	8	295	0
	NAS1611-013	8	176	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	157	0
	D2741	1	41	0
	D3493-1	2	35	0
	D3532-1	2	57	0
	MS21083C8	2	110	0
	NAS1149D0863J	2	407	0
Part Specifications				
Specifications could not be found.				

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DECEMBER

2018 OCT 19 14:07

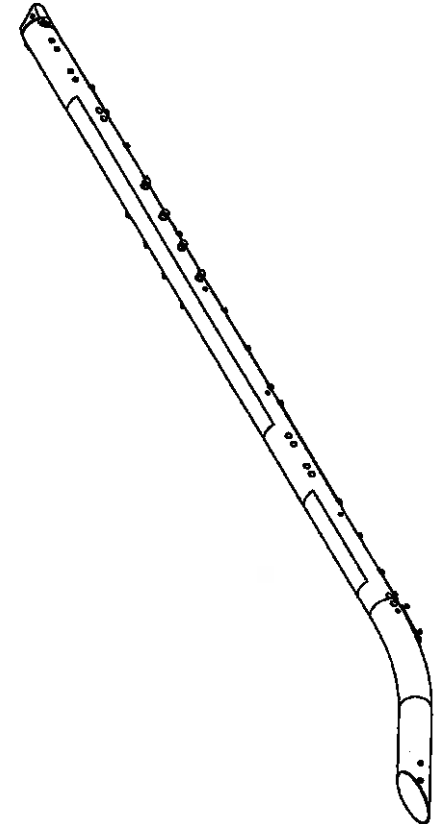
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CHECKED	MRW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 2 OF 10
DE APPR.	NO	TITLE	SCALE
DATE	18.03.05	350 SKIDTUBE ASSEMBLY	NTS
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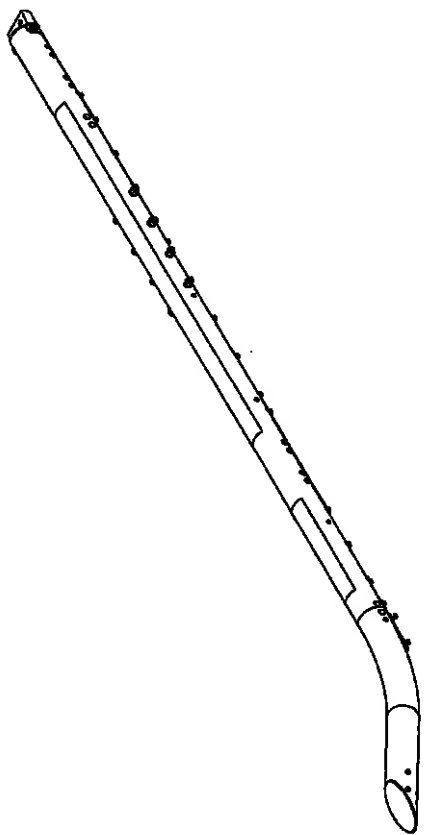
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D D C B A



D2750-043 350 SKIDTUBE ASSEMBLY, LH

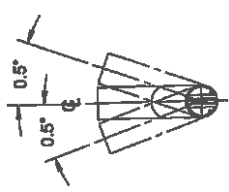


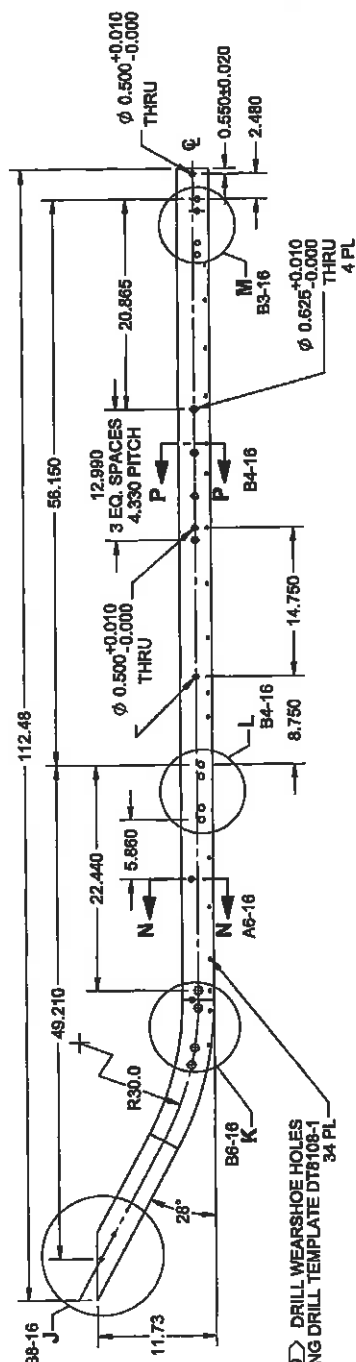
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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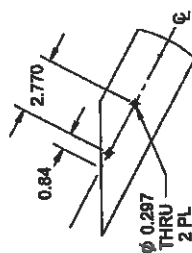




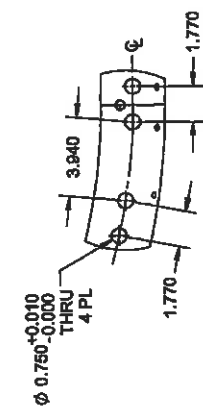
9 DRILL WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1
34 PL-

**MAX ALLOWABLE
TWIST ON FWD BEND
(NEW LOOKING FWD)**

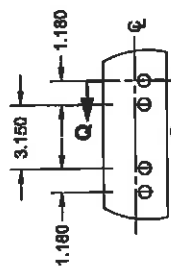
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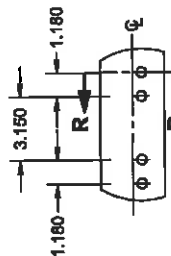
D7-6
DETAIL J
SCALE 2X



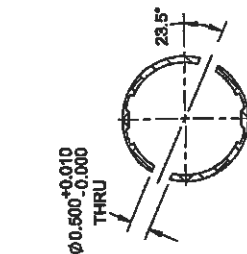
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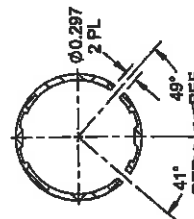
D5-6
DETAIL 1
SCALE 2X



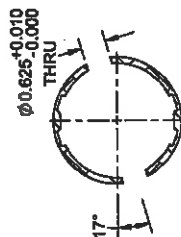
D3-6
DETAIL M
SCALE 2X



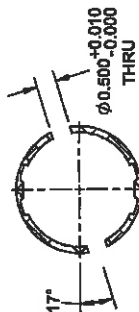
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SECTION N-N
SCALE 4X, 2 PL



D4-6
SECTION P-P
SCALE 4X, 17 PL



B4-6
SECTION Q-Q
SCALE 4X, 4PL



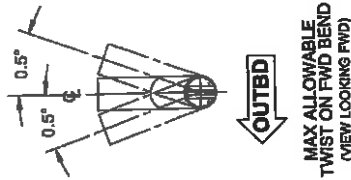
SECTION R-R
SCALE 4X 4 PL

THRU
500 +0.010
500 -0.000

SECRET

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**MAX ALLOWABLE
TWIST ON FWD BENN
(VIEW LOOKING FWD)**

Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and a hole. The part is a rectangular plate with a hole. Dimensions include a total width of 2.770, a hole diameter of 0.297, and a distance of 0.84 from the left edge to the hole center. The hole is labeled "THRU 2 PL".

Technical drawing of a circular part. A dashed line indicates a 17° angle. A hole is shown with a diameter of $\varnothing 0.525^{+0.010}_{-0.000}$ and a label "THRU" indicating it is a through hole.

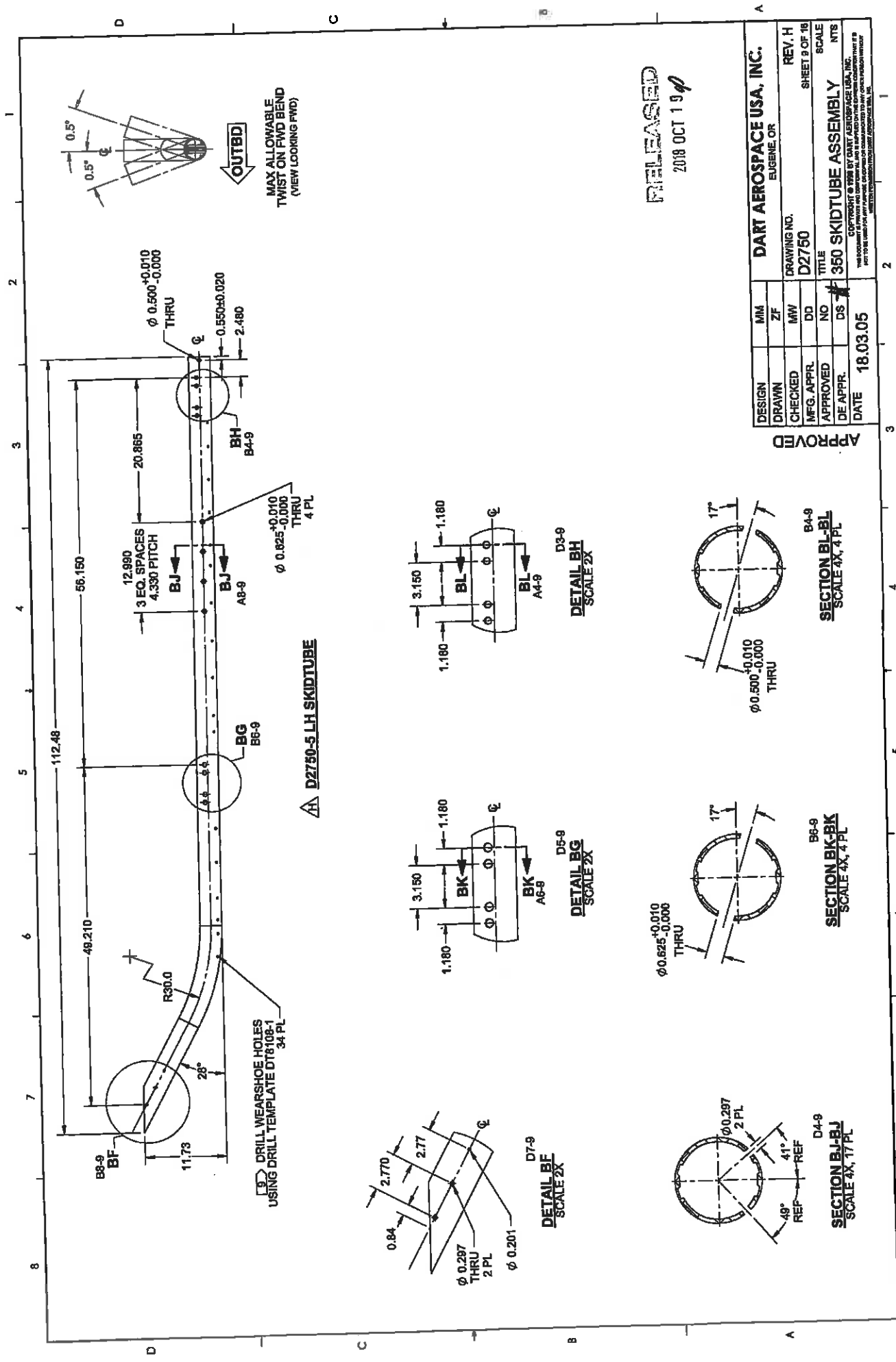
Technical drawing of a circular part. The drawing shows a circle with a center point. A line passes through the center at an angle of 17 degrees. The diameter is labeled as $\varnothing 0.500-0.000$ THRU.

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DATE	18.03.05	SCALE
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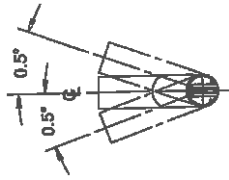
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(VIEW LOOKING FWD)



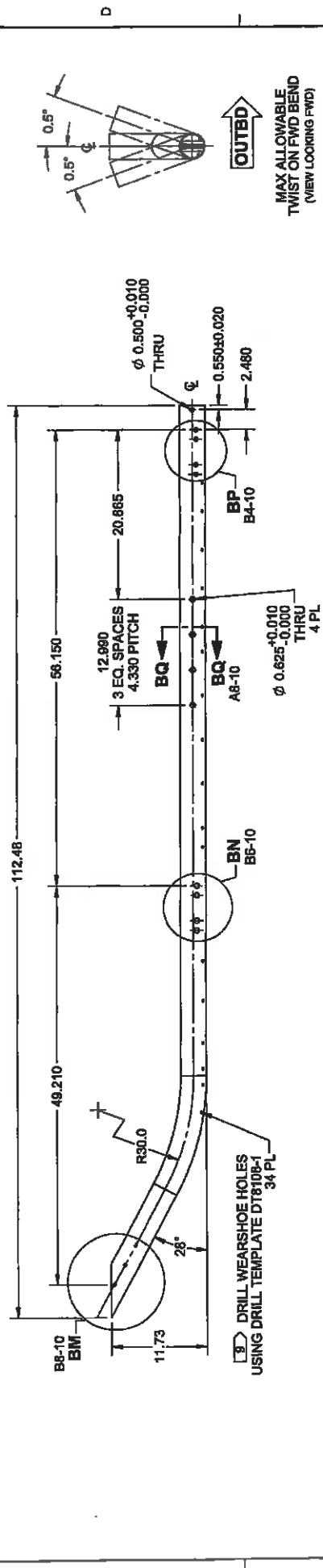
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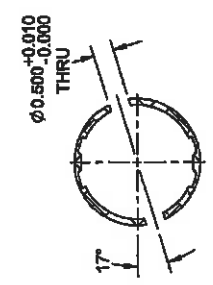
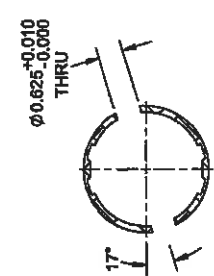
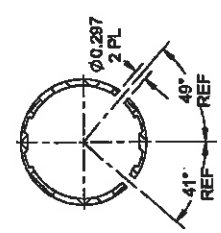
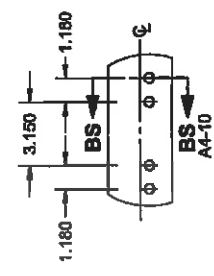
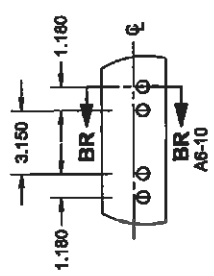
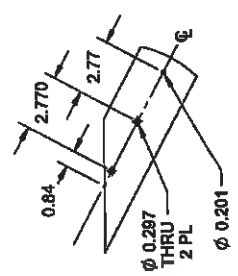
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1 2 3 4 5 6 7 8



D2750-6 RH SKIDTUBE



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REV. H			
SHEET 10 OF 16			
TITLE	350 SKIDTUBE ASSEMBLY		
SCALE	NTS		
DATE	18.03.05		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____

5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT
D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN6C21A	BOLT
11	2	2	2	2	2	2		NAS1149D0863J	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

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Revision: K

Date: 18.04.04

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
*22A	1	1	1	1	1	1	1	D3791-1	WEARPLATE
*23A	1	1	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*24A	1	1	1	1	1	1	1	D3793-5	WEARSHOE (REPLACES D3535-25)
*25A	1	1	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*26A	34	34	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	34	34	NAS1149C0332R	WASHER
*28	34	34	34	34	34	34	34	ALS4-1032-225	INSERT
								D3492-041	PLUG ASSEMBLY
*30	8	8	8	8				D3492-043	PLUG ASSEMBLY
*31	8	8		8				D3492-045	PLUG ASSEMBLY
*32			8	8					
***43	2	2	2	2				D3493-1	WASHER
								D3532-1	SPACER
50	2	2							
								AN3C34A	BOLT
****97					1	1		NAS1149C0363R	WASHER
****98					2	2		MS21043-3	NUT
****99					1	1		AN526C1032R10	SCREW
100A							4	AN526C1032R18	SCREW
100B							4		

- * PART OF D2750-041/-042, D2750-043/-044 OR D2750-051/-052 ASSEMBLY
- ** TO BE SUPPLIED BY CUSTOMER
- *** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM
- **** PART OF D2750-051 OR D2750-052 ASSEMBLY

Change Record

PAGE 1 OF 1

Part Number: D350-636-011/-011GB/-012/-012GB

Description: SKIDTUBE STD LH/RH, FLOAT COMPATIBLE

[illegible]